

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011689**Date Inspected:** 25-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY 1**

This QA Inspector observed the following work in progress:

**Flux Core Arc Welding (FCAW):**

Weld joint # 002 located on Traveler Rail Bracket 13TB1 – 173. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 002 located on Traveler Rail Bracket 13TB1 – 184. Welder is identified as 216575. ZPMC Quality Control (QC) Inspector is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

**BAY 2**

This QA Inspector observed the following work in progress:

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### Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Traveler Rail 20TR1 – 001. Welder is identified as 045240. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

Weld joint # 005 located on Traveler Rail 20TR1 – 013. Welder is identified as 045227. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

### BAY 5

This QA Inspector observed the following work in progress:

### Surface Welding by Flux Core Arc Welding (FCAW):

Surface welding being carried out according to Critical weld repair (CWR) report #B-CWR1102 located on Traveler Rail 11TR3 – 016. Welder is identified as 215689. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G(1F)-Repair-1. (See attached Photo)

Surface welding being carried out according to Critical weld repair (CWR) report #B-CWR1102 located on Traveler Rail 11TR3 – 023. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G(1F)-Repair-1.

### BAY 6

This QA Inspector observed the following work in progress:

### Flux Core Arc Welding (FCAW):

Weld joint # 001 located on U-rib connection plate USPL1 – 304. Welder is identified as 048625. ZPMC Quality Control (QC) Inspector is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 002 located on U-rib connection plate USPL1 – 306. Welder is identified as 051246. ZPMC Quality Control (QC) Inspector is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

### BAY 7

This QA Inspector observed the following work in progress:

### Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 005 according to weld repair report #B-WR10296 located on Traveler Rail

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10TR1 – 016. Welder is identified as 066695. ZPMC Quality Control (QC) Inspector is identified as Cui Junjie. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Repair welding of a weld joint # 005 according to weld repair report #B-WR10069 located on Traveler Rail

11TR3 – 013. Welder is identified as 070008. ZPMC Quality Control (QC) Inspector is identified as Cui Junjie.

The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

BAY 8

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 014 according to weld repair report #B-WR10411 located on Traveler Rail

11TR10 – 002. Welder is identified as 054459. ZPMC Quality Control (QC) Inspector is identified as Sun Bo.

The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No Relevant Conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

**Reviewed By:** Hall,Steven

QA Reviewer